

Armaloy PC/ABS-1IM

High heat resistant and high impact modified PC/ABS blend. Injection molding grade for automotive, household appliances and other applications.

	Method	Unit	Data
PHYSICAL			
Density	ISO 1183	g/cm ³	1,13
Melt Flow Rate (260°C; 5 kg)	ISO 1133	g/10 min	22
Shrinkage	ISO 294-4	%	0,45-0,75
Burning rate	ISO 3795	mm/min	42
MECHANICAL			
Tensile strength at break	ISO 527-2	MPa	48
Elongation at break	ISO 527-2	%	50
Flexural Modulus	ISO 178	MPa	2200
IMPACT			
Charpy notched impact strength at +23°C	ISO 179/1eA	kJ/m ²	56
Charpy notched impact strength at -30°C	ISO 179/1eA	kJ/m ²	40
THERMAL			
Heat deflection temperature, 1,8 Mpa	ISO 75-2	°C	106
Heat deflection temperature, 0,45 Mpa	ISO 75-2	°C	114
Vicat softening temperature, 50H	ISO 306/ B120	°C	120
PROCESSING PARAMETERS			
Processing (melt) temperature		°C	250-260
Mold temperature		°C	85±5
Residual humidity		%	0,02-0,04
Drying temperature		°C	90±5
Drying time		hours	3-4

Notes

Material properties indicated in the present document shall be considered as typical. Customer shall determine independently if it is necessary to use this or any other material for the specific application. Processing recommendations for the material are provided for reference only and will vary depending on processing method and product characteristics.

Transportation and Storage

Material can be transported with any kind of covered vehicle, ensuring protection from atmospheric precipitation, insolation, contamination and damages, in accordance with transportation rules of the vehicle used.

Material shall be stored in a covered warehouse on the pallet at a distance not less than 1 meter from heating devices.

Comment:

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The information in this technical description is for reference purposes only. It can be considered as the basis for determining whether material is acceptable for specific applications. Because it is not possible to anticipate all applications of materials and operating conditions, POLYPLASTIC makes no warranty and assumes no liability for the use of the information specified in the catalog. This information may be changed without notice.